

Work Order ID 75258

October-19-11 1:37:28 PM

75258

Page 1

Item ID: D3269-2

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bubble Window, RH

Stop

NS2

Start Date: 19/10/2011 **Start Qty:** 2.00

2

Cust Item ID:

Required Date: 07/11/2011 **Req'd Qty:** 2.00

2

Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 11/10/11

Tooling:

Date:

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|----------------------------------|------------------------------|----------------|---------------|----------------------|-----------------------|-----------------------|--------------------------|------------------------|
|--|----------------------------------|------------------------------|----------------|---------------|----------------------|-----------------------|-----------------------|--------------------------|------------------------|

| Draw Nbr | Revision Nbr |
|-----------------|---------------------|
| D3269 | Rev E |

100 0.00

100 HAND FINISHING THERMOFORMING

Thermoform

Memo 0.00

Thermoforming Machine Set up Clamping Frame and Load Programas per Folio FTA 014

JL
11/12/08

110 0.00

110 HAND FINISHING THERMOFORMING

Thermoform

Memo 0.00

Thermoforming Machine Cut Blanks to 30" by 48"

x2 JL
11/12/08

120 0.00

120 THERMOFORMING MACHINE

Thermoform

Memo 0.00

Thermoforming Machine Thermoform as per Dwg. D3269 and Folio FTA 014 Dwg. Rev.

E C

x2 JL
11/12/08

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | | |
| | | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 75258***75258***

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Cust Item ID:

Required Date: 07/11/2011 Req'd Qty: 2.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC2- Inspect parts off machine FAI/FAIB

0.00

130

QC

Quality Control

Memo

0.00

x2

Dh
11/12/08

140

QC8- Inspect parts - second check

0.00

140

QC

Quality Control

Memo

0.00

Sun 12/12

x2

150

HAND FINISHING THERMOFORMING

0.00

150

Thermoform

Thermoforming Machine

Memo

0.00

1) Trim off excess flange material2) Buff out any light scratches or blemishes3) Etch part number and batch number

x2

Dh
11/12/12

| W/O: | | WORK ORDER CHANGES | | | | | |
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Work Order ID 75258

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Page 3

Item ID: D3269-2

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Bubble Window, RH

Stop

NS2

Start Date: 19/10/2011 **Start Qty:** 2.00

2

Cust Item ID:

Required Date: 07/11/2011 **Req'd Qty:** 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Suue13

(X)

Quality Control

1) Visually inspect for clarity, and proper formation.

170

Identify as per dwg & Stock Location: *170*

0.00

170

Packaging

Memo

0.00

11/12/13 @

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

W/12/13 @

MF

11-12-13

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NOTE: Date & initial all entries

Picklist Print

October-19-11 1:37:31 PM

Page 1

Work Order ID: 75258

75258
D3269-2

Parent Item: D3269-2

Parent Item Name: Bubble Window, RH

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP A 05.03.22 New issue KJ/JLM
 IPP B 05.05.09 Added engraving EC
 IPP Rev:06-07-03 As per Rev C JLM
 IPP C 07.11.06 Thermoform in-house DL verified by:EC
 IPP Rev: D 08.07.24 As per New Tool DL.

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MACRYLICS.177 | | Purchased | No | | | | sf | 44.6239 | | 24.12211 | | | |

MACRYLICS 177
0.177" PLEXIGLAS G CLEAR CAST ACRYLIC SHEET

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| therm | 44.623895 | |
| 116796 | 44.623895 | |

119509

**

11/12/08

24.12211 sq ft

| W/O: | | WORK ORDER CHANGES | | | | | | |
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NOTE: Date & initial all entries

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|--------------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 75258 |
| Description: Bubble Window, RH (R44) | Part Number: | D3269-2 |
| Inspection Dwg: D3269 Rev: E | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

THERMOFORMING SECTION

| Description | Accept | Reject | Method of Inspection | Comments |
|---|--------|--------|----------------------|----------|
| Depth of bubble within tolerances | ✓ | | | |
| Shape Definition | ✓ | | | |
| Material imperfections such as bumps, cracks, voids, scratching | ✓ | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |

Measured by:

Date:

ii/12/08.

TRIMMING SECTION

Measured by:

Date:

11/12/12

Audited by:

Date:

11/21/13

Prototype Approval:

Date:

| Rev | Date | Change | Revised by | Approved |
|------------|-------------|----------------------------------|-------------------|---|
| A | 08.11.27 | New Issue | KJ/DL |  |
| B | 09.10.16 | Tolerances revised per Dwg Rev E | KJ |  |

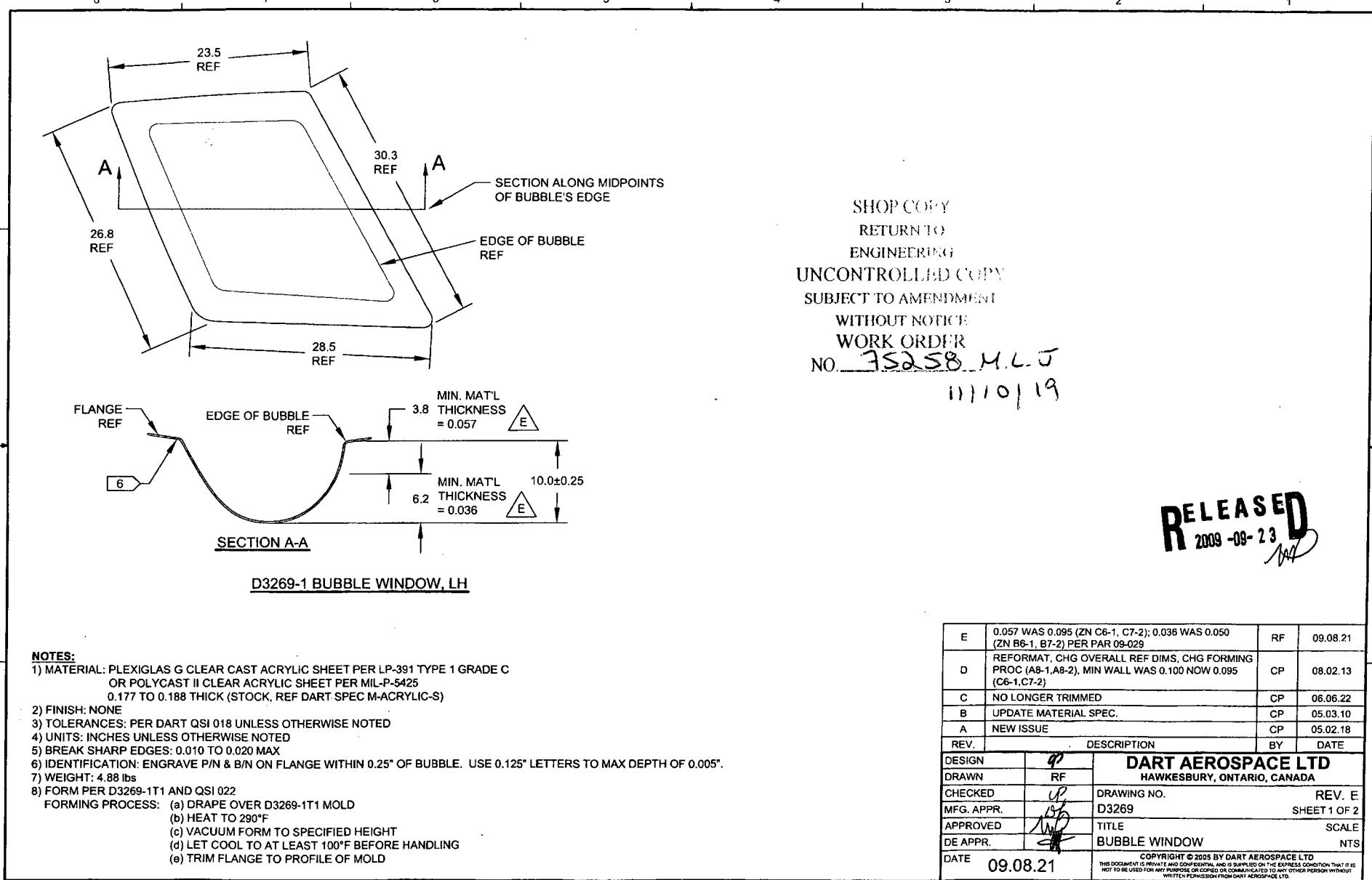
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NOTE: Date & initial all entries



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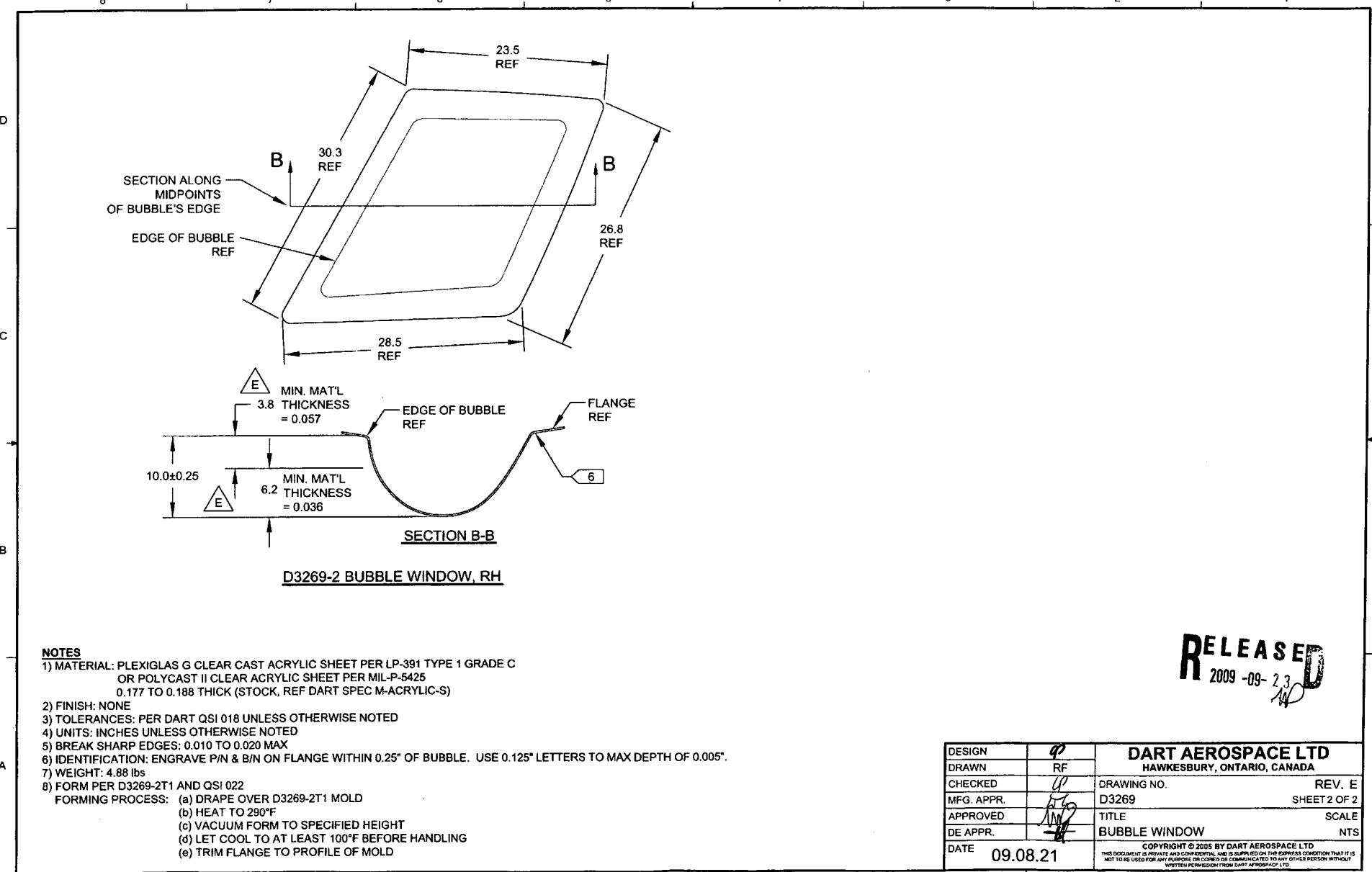
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NOTE: Date & initial all entries

752-58



| W/O: | | WORK ORDER CHANGES | | | | | | | |
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